

Date: Thursday, 2/22/2007 2:57:44 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 30813D		
Estimate Number	: 10356		
P.O. Number	: N/A	Part Number	: D2279
This Issue	: 2/22/2007 S.O. No. : N/A	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 29922D	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 2/6/2007
Checked & Approved By	: <u>[Signature] 07.02.23</u>	Qty:	10 Um: Each
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.5435 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2279
 Batch: M102448

SAN 02/02/28 (10)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D 2279
 Dwg Rev: D
 Prog Rev: D

2-Debur if necessary

SAN 07/02/28 (10) PTO
 FF 07-03-06 10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/02/28 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/03/01 (10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form As per Dwg D2279

SAN 07/03/13 (9) PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 07/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/18	2.0	holes were to big, had to change Mixing tube 2 piece scrap	<i>[Signature]</i>	Scrap & destroy and replace (2)	07/02/18 <i>[Signature]</i>	07/03/01 <i>[Signature]</i>	<i>[Signature]</i>	07/03/01 <i>[Signature]</i>
07/03/13	5	1 piece was out of tolerance at the set-up for bending	<i>[Signature]</i>	Scrap - destroy No replace	07/03/13 <i>[Signature]</i>	07/03/13 <i>[Signature]</i>	<i>[Signature]</i>	07/03/13 <i>[Signature]</i>

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/13 (9)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.A.

07/03/14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/15 (9) Lu

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

07/03/15 (9) Lu

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/15 (9)

Job Completion



07.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

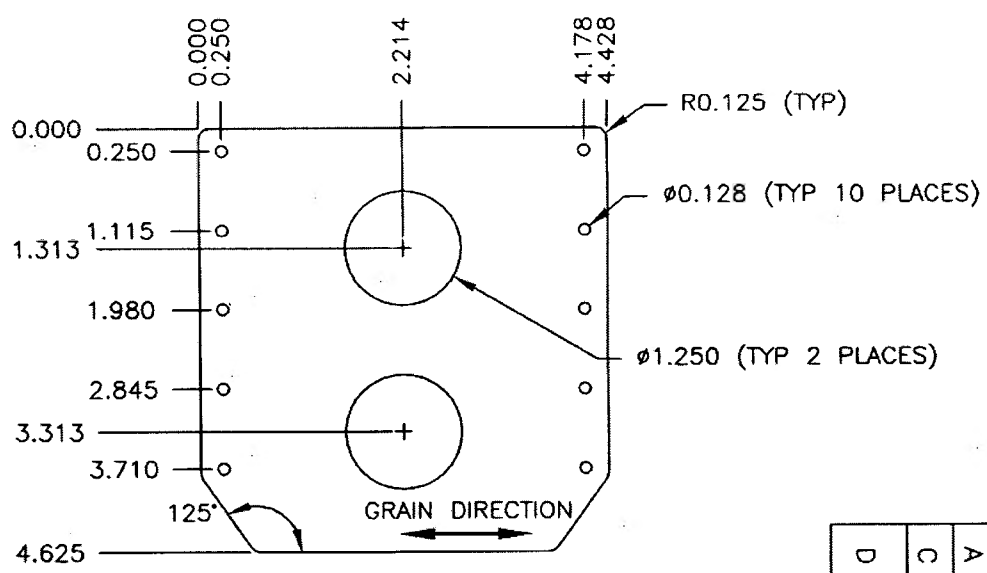
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

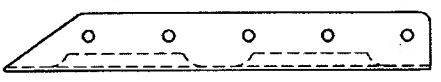
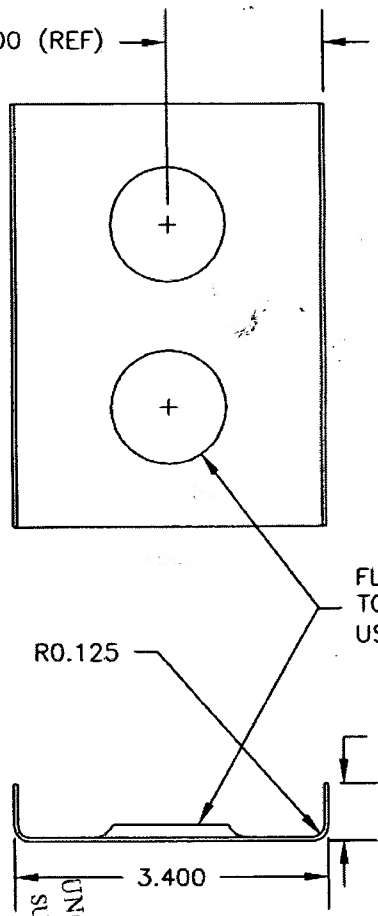


DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		JP		HAMKESBURY, ONTARIO, CANADA	
CHECKED	RE	APPROVED	HT	DRAWING NO.	REV. 0
DATE	98.10.05	TITLE	STEP SPACER	D2279	SHEET 1 OF 1
				SCALE	1:2
A	94.10.13	NEW ISSUE			
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881			
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912			



FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



RELEASED
98.10.08 DS

UNDER REVIEW

DESIGN OK, BUT CHECK WITH
TSR BEFORE MANUFACTURE

OK 4/11/09

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
308131

